

Need for space bar

Date: Thursday, 10/11/2007 2:54:14 PM
User: Kim Johnston

Thurs 16/10

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GUIDE
Job Number	: 35122		
Estimate Number	: 10367		
P.O. Number	: N/A	Part Number	: D31121
This Issue	: 10/11/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3112 REV B
First Issue	: N/A	Project Number	: N/A
Previous Run	: 27667	Drawing Revision	: B
		Material	: N/A
		Due Date	: 10/18/2007
Written By	: <u>JA 0710 11</u>	Qty:	1512
Checked & Approved By	: <u>JA 0710 11</u>	Um:	Each
Comment	: Est. A 02.05.22 New Issue NG		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	M6061T6B0625X01500	6061-T6 Bar .625" x 1.5"
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Comment: Qty.: 0.2385 f(s)/Unit Total: 1.4307 f(s)
6061-T6 Bar .625 X 1.500"
Material: 6061-T6/T6511/T651 (QQ-A-225/8 OR QQ-A-200/8)
Bar ref DART spec M6061T6B
Batch M101549

JA 07-10-16

(18)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
Cut blanks: 0.625" x 1.500 bar x 2.625" long.

JA 07-10-16

(18)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Machine as per Folio FA233
Note: Engrave / scribe DART P/N on part as per dwg.
Deburr break all unmarked sharp edges .005 to 0.010

J-L 07/10/18

(12)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J-L 07/10/18

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J-F 07/10/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 07/10/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/11/2007 2:54:14 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUIDE

Job Number: 35122

Part Number: D31121

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MS

07-10-19 (12)

7.0

POWDER COATING

POWDER COATING



M104846



(12x)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m-h

07/10/22

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



MS



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07-10-22

(12x)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: ST65

7/10/23

(12)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(12)

Comment: FINAL INSPECTION/W/O RELEASE

07/10/23

Job Completion



07.10.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

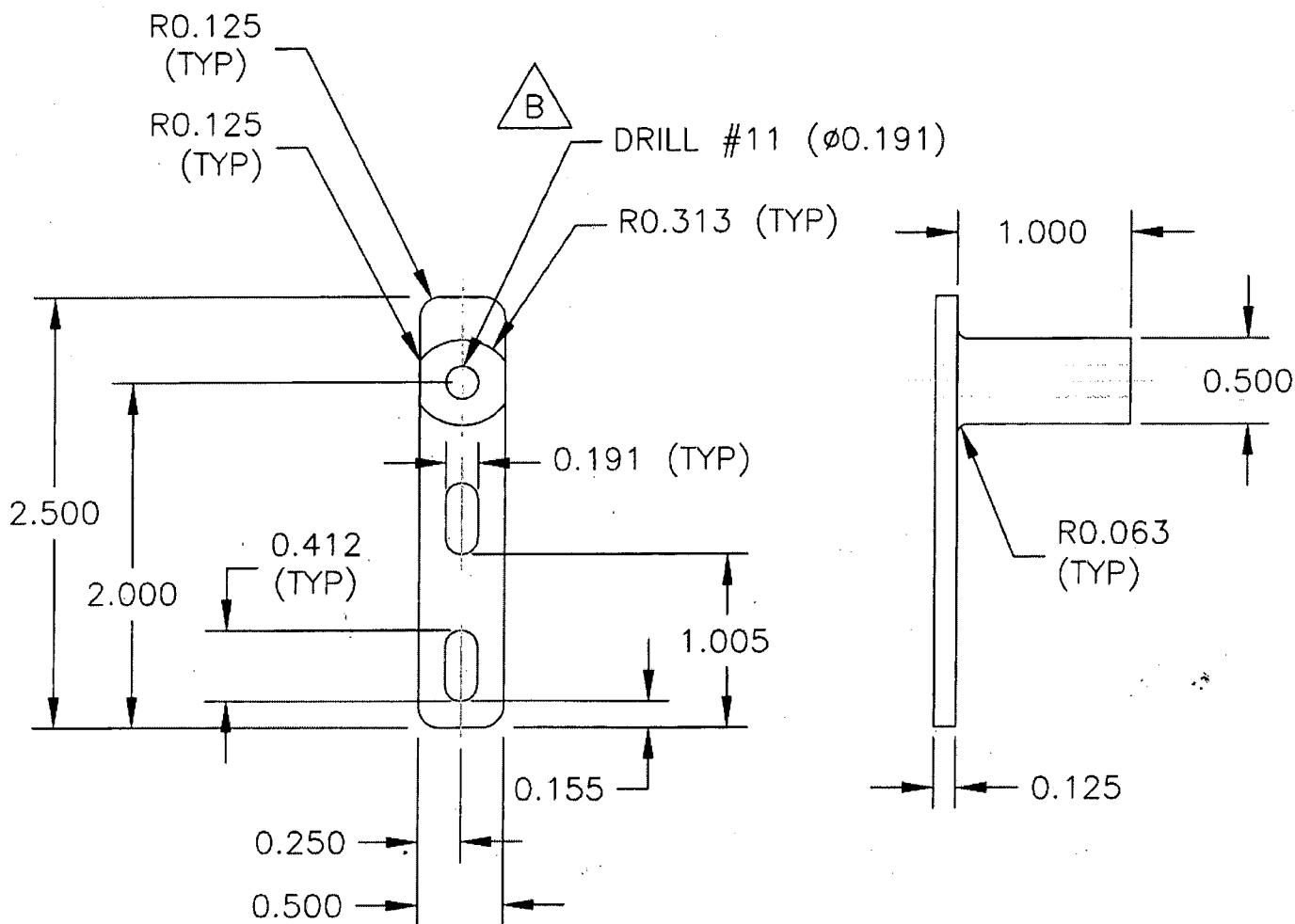
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3112	REV. B SHEET 1 OF 1
DATE 04.10.18		TITLE GUIDE	SCALE 1:1
A	02.04.12	NEW ISSUE	
B	04.10.18	ADD PART MARKING; $\phi 0.191$ WAS $\phi 0.185$	

RELEASED
04.11.23



D3112-1 GUIDE

NOTES:

- 1) MATERIAL: 6061-T6/T6511/T651 (QQ-A-225/8 OR QQ-A-200/8)
BAR (REF. DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015.
- 6) POSSIBLE SUPPLIER: PREMIER P/N B30-23000-17
- 7) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35122

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